

Date: Tuesday, 7/18/2006 2:33:49 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B STEP ASSY, LH  
 Job Number : 27936A  
 Estimate Number : 11698  
 P.O. Number : N/A Part Number : D2721041  
 This Issue : 7/18/2006 S.O. No. : N/A Drawing Number : D2721 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : C  
 Previous Run : 24101A Material : N/A  
 Written By : Due Date : 8/15/2006 Qty: 4 Um: Each  
 Checked & Approved By : 06.07.19  
 Comment : Est Rev: F As Per Ecn 766 06-01-06 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty Part # Description Batch:  
 1 D2622-120C Extrusion 327077

Check Material for any Dents or Defects

06.07.25

4

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2721-1 using D2622 extrusion as per Dwg D2721  
 Deburr and bevel ends for welding

06.07.25  
06.07.25

4

4

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number Description Batch  
 2 D2734 End Cap 327281 4  
324402 4

06.07.25

4

4.0 D34611 PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

206 Step Lug

Pick:

Qty Part Number Description Batch  
 1 D3461-1 Plate 324311

06.07.25

4

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr		Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date & initial all entries

NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D2721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34613

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3461-3	Plate	<u>326312</u>

*SE. 06.07.25* 4

6.0

D34615

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3461-5	Plate	<u>326313</u>

*SE. 06.07.25* 4

7.0

D34617

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3461-7	Plate	<u>326314</u>

*SE. 06.07.25* 4

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT

followed by Jig DT

A/R AL Rod Batch: M100660

Grind end cap welds flush

*SE. 06.07.26* 4  
*SE. 06.07.26* 4  
*SE. 06.07.26* 4

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*FM 06/07/27 (4)*

W/O:		WORK ORDER CHANGES							
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr		Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

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Job Number:



Seq. #: Machine Or Operation: Description :

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

MF. 06/07/31

(4)

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LE. 06.8.2

4

12.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

LE. 06.8.3

4

Weld Remaining end cap as per Dwg D2721 using Jig DT followed by Jig DT

LE. 06.8.3

4

A/R AL Rod

Batch: M15689  
M100660

Grind End Cap Welds Flush

LE. 06.8.3

4

13.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

J0809(4)

06/08/10 (4)

14.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Alodine

DL 06/08/11 (4)

15.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

am 06-08-16

(4)

16.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/08/16 (4)

W/O:		WORK ORDER CHANGES							
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 06/08/27

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



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Machine Or Operation:

Description :

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2721 and QSI 00 5 4.4

SC 06/08/16

(4)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PU 6/8/22

(4)

Sign

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

N/A

20.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.08.23

Job Completion



06-08-23

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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



